

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019433**Date Inspected:** 08-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai , China

<b>CWI Name:</b>	Shi Lei (east) Bao Lei Zhang (west)			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b> <b>N/A</b>
<b>Bridge No:</b>	34-0006			<b>Component:</b>	OBG Deck Panels	

**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Kenneth Riley was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China.

**Trial Assembly**

On this date the QA inspector was present at ZPMC and witness ABF inspectors performing Magnetic Particle (MT) testing of weld number OBW8-005 located at Cross Beam (CB) Edge plate under item 1 on ABF

Verification witness request 06072010-2. The three (3) Y locations that were tested were 100mm, 380mm and 900mm. These area had acceptable results from the MT test. The ABF QC personell were identified as Shen Jian and You YiLin.

**Bay 5**

This Caltrans QA inspector observed ZPMC performing welding on the traveler rails in Bay 5 at approximately 0000hr (midnight) with no ZPMC Quality Control (QC) personnel or ZPMC Certified Welding Inspector (CWI) onsite. When this QA inspector asked for the ZPMC QC-CWI he was told no (mao,mao). ABF Representative Wang Wan Sheng did arrive shortly after the incident and when asked about the QC-CWI he also stated no. It was observed that 2 welders were still in bay 5 and this QA Inspector asked for the welder's Identification card and the welder refused to give the QA Inspector his card for identification purpose. As this QA Inspector entered the bay the welders left the immediate welding location and this QA Inspector was unable to identify the exact weld(s) that were being welded at this time.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

No Conversations This date.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Riley,Ken	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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